

Work Order ID 73076

Thursday, August 25, 2011 11:43:25 AM



Aug 31st

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Item ID: D3752-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Seat Frame

Start Date: 8/25/2011 Start Qty: 5.00



Cust Item ID:

Required Date: 8/31/2011 Req'd Qty: 5.00



Customer:

Reference:

Run Start



Approvals: Process Plan: UMF Date: 11-08-25

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3752

Rev C

100

0.00



HandThermo

Memo

0.00

Hand Finishing Thermoforming

Cut sheet to required size

✓

11/08/30

105

0.00



HandThermo

Dry Material

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QSI022 POLYCARBONATE

Temp: 240°F

Time IN: 5:00 pm 11/08/29

Time OUT: 7:00 am 11/08/30





✓



11/08/30




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Item ID:	D3752-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Seat Frame					
Start Date:	8/25/2011	Start Qty:	5.00		Cust Item ID:	
Required Date:	8/31/2011	Req'd Qty:	5.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 	Thermoform	0.00							
Thermoforming Machine	Memo Thermoform as per Dwg. D3752 and folio (FTA022) using tool DT 8997	0.00				x6			Dh. 11/08/30.
	Dwg. Rev. <u>C</u> Folio Rev. <u>C</u>								
120 	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00				x6			Dh. 11/08/30
Quality Control									
130 	QC8- Inspect parts - second check	0.00							
QC	Memo	0.00				8			11/08/02
Quality Control						x6			

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Item ID: D3752-1	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Seat Frame					
Start Date: 8/25/2011	Start Qty: 5.00		Cust Item ID:		
Required Date: 8/31/2011	Req'd Qty: 5.00		Customer:		
Reference:					

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 	HandThermo	0.00							
Hand Finishing Thermoforming	Memo 1) Trim to Finished Dimensions	0.00				x6			Wh 11/08/30
150 	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00				x6			Wh 11/08/30
Quality Control									
160 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							5 ul 09/02
Quality Control						(46)			

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Item ID: D3752-1

Accept

Revision ID:

Item Name: Seat Frame

Start Date: 8/25/2011 Start Qty: 5.00

Required Date: 8/31/2011 Req'd Qty: 5.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

Identify as per dwg & Stock Location: 252A

0.00



Packaging

Memo

0.00

Packaging

11/9/2 SL (Signature)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/9/2 (Signature)
ME
11-09-2

Picklist Print

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Page 1

Work Order ID: 73076



Parent Item: D3752-1



Parent Item Name: Seat Frame

Start Date: 8/25/2011

Required Date: 8/31/2011

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP REV: A New Issue 08.06.03 DL verified by:DD
IPP Rev. B Dwg. Update 08/07/22 DL IPP Rev. C
Dwg. Update Shorter length 08/10/28 DL IPP Rev D Add Step 105
Dry Material 10/04/21 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MLEXS.125-F60029-04		Purchased	No			100	sf	1,229.178	10.667	53.335			
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GE PLASTICS LEXAN SHEET

Location

Loc Qty

Loc Code

MAT018

1229.178289

116236

1229.17829

64.002 sq. ft.

11/08/30.

DART AEROSPACE LTD		Work Order:	73016
Description: Seat Frame		Part Number:	D3752-1
Inspection Dwg: D3752	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Shape Definition	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			
Edges and corners such as thinness, cracks and sharp edges	✓			

Measured by:	OK	Date:	11/08/30
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TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.028	Min	0.056"	✓		ULTRA	
0.035	Min	0.062"	✓		ULTRA	
0.040	Min	0.062"	✓		Vern TH-01	
0.075	Min	0.121"	✓		ULTRA	
0.052	Min	0.093"	✓		ULTRA	
0.021	Min	0.033"	✓		Vern TH-01	
0.036	Min	0.091"	✓		Vern TH-01	

Measured by:	OK	Date:	11/08/30
Audited by:	S	Date:	11/07/02
Prototype Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	08.11.28	New Issue	KJ/DL	OK

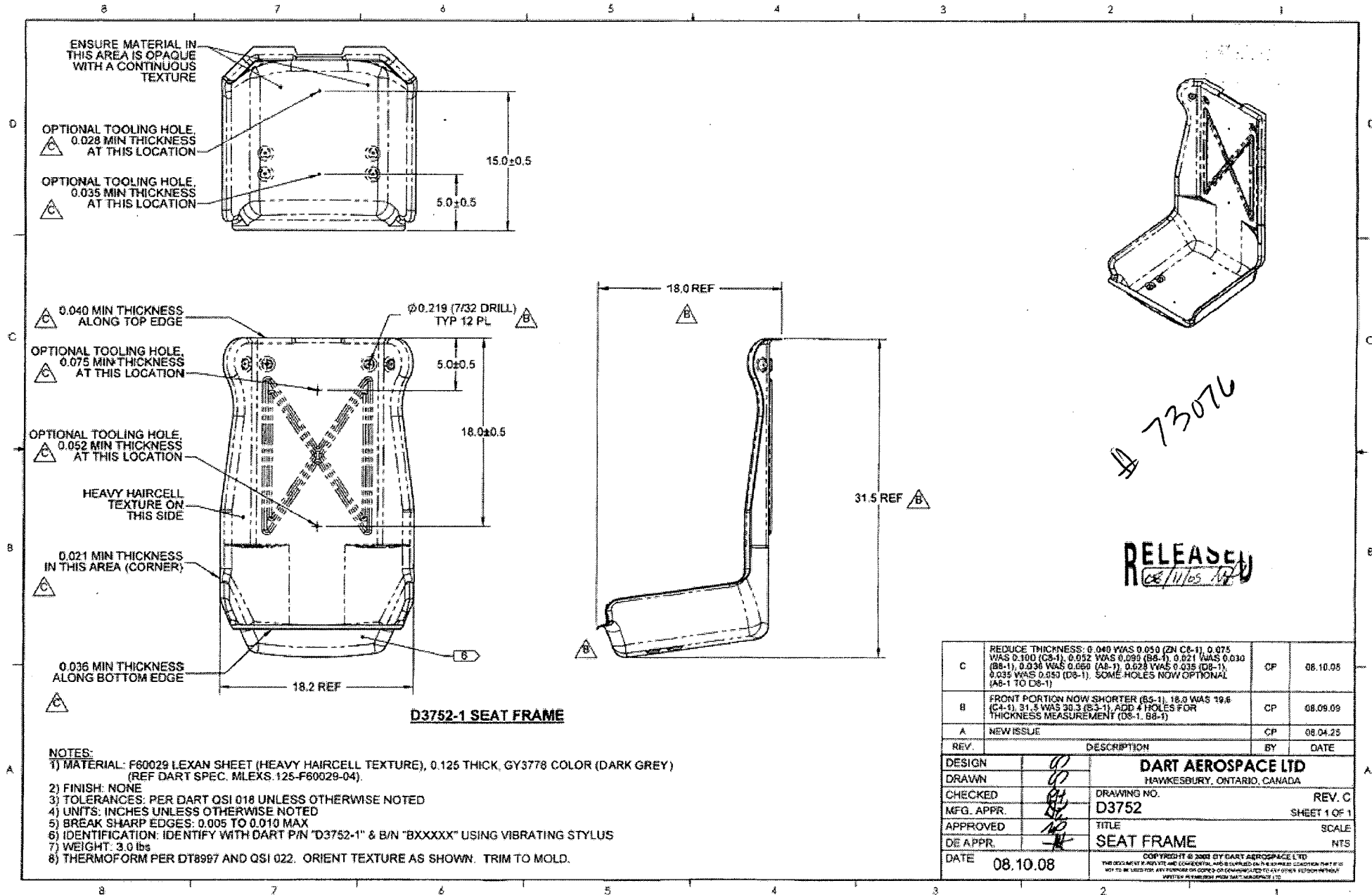
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries